

Date: Tuesday, 5/9/2006 7:44:39 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
 Job Number : 27041 -2
 Estimate Number : 12411
 P.O. Number : N/A Part Number : D35011
 This Issue : 5/9/2006 S.O. No. : N/A Drawing Number : D3501 PRELIMINARY
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : PRELI
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 5/10/2006 Qty: 32 Um: Each
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est Rev:A New Issue 06-05-09 JLM (30)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.0831 f(s)/Unit Total: 2.6578 f(s)

303 Round Bar .75"

(M303R0750)

Batch: M100629

M100157 MS 06/06/01

06/05/17

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA & DWG D3501,

FOLIO REV: N/A (done on manual)

DWG REV: A

2-DEBURR AS REQUIRED

J.G. 06/06/01

06/05/17

30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G. 06/06/01

06/05/17

30

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.G. MS 06/06/01

06/05/17

30

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST45

AR 06/06/01

(30)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/9/2006 7:44:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27041

Part Number: D35011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

20/06/02 (30)

Job Completion



U 060602

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | |
| | | | | | | | | |
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

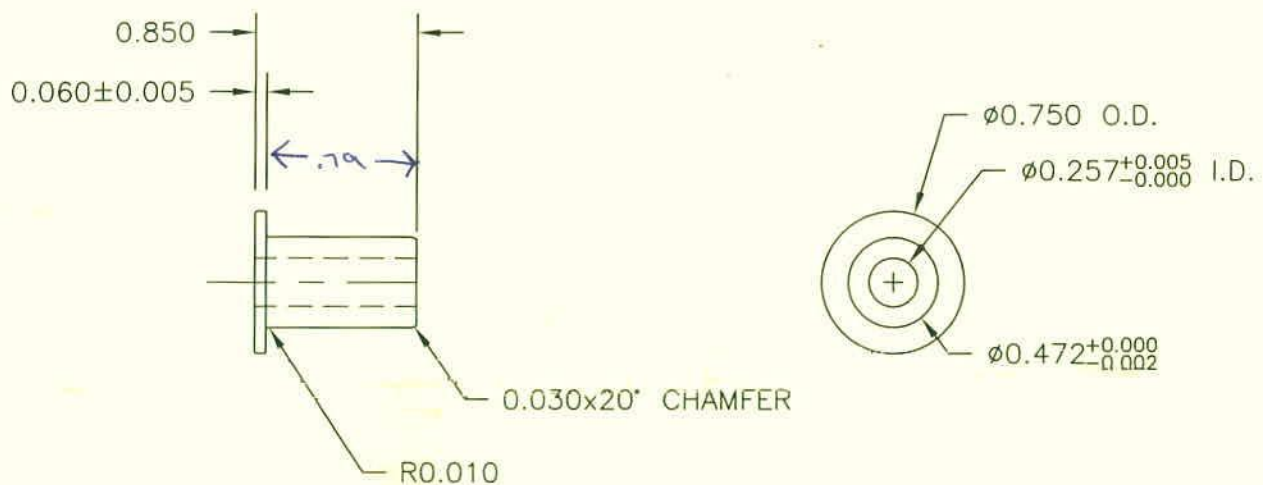
QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

06.04.17

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN qp | DRAWN BY qp | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3501 | REV. A SHEET 1 OF 1 |
| DATE 06.04.18 | | TITLE BUSHING | SCALE 1:1 |
| A | 06.04.18 | NEW ISSUE | |

Qty (16) (32)



D3501-1 BUSHING

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

5.000
1.004
1.005

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|--|-------------|---------------------|
| DART AEROSPACE LTD | | Work Order: |
| Description: Crosstube Assembly | | Part Number: |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|------|------------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | .850 | ± .010 | .847 | ✓ | | | |
| | .060 | ± .005 | .056 | ✓ | | | |
| | .257 | + .005 - .001 | .260 | ✓ | | | |
| | .472 | + .002 - .002 | .4713 | | | | |
| | .750 | ± .010 | .748 | ✓ | | | |
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| SIDE B | | | | | | | |
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| Measured by: JL | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 06/06/01 | Date: 06/06/01 | Date: | N/A |

| | | | | |
|------------|-------------|---------------|-------------------|-----------------|
| Rev | Date | Change | Revised by | Approved |
| A | | New Issue | KJ/JLM | |